

Work Order ID 63575

Thursday, November 04, 2010 1:10:17 PM



Page 1

Item ID: D3564-5

Revision ID:

Item Name: Wearshoe

Start Date: 11/4/2010 Start Qty: 12.00

Required Date: 11/12/2010 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:



Date: 10-11-09

Tooling:

Date:

Setup Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

10-11-16

FLOW CNC Waterjet

304 .063

1-Cut as per Dwg D3564 Dwg Rev: Prog Rev: 2-
Deburr if necessary

(12)

110

0.00



QC

Memo

0.00

10-11-16

Quality Control

120

0.00



QC

Memo

0.00

S 10-11-16

Quality Control

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63575

Page 2

Thursday, November 04, 2010 1:10:17 PM

Item ID: D3564-5

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

NC BRAKE

Set Up/
Run Hours

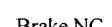
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC



Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

140

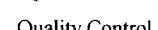


QC5- Inspect part completeness to step on W/O

0.00

SB 10/11/30

QC



Memo

0.00

Quality Control



Ensure joggle as per dwg D3429

150

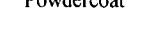


Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

12 BK 10-11-30

Powdercoat



Powder Coating

Memo

0.00

START TIME: 11:00 OVEN TEMPERATURE: 300°

FINISH TIME: 11:30

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 63575

Thursday, November 04, 2010 1:10:17 PM



Page 3

Item ID: D3564-5

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M

10/11/30

12 0

170



Packaging

Packaging

Identify as per dwg & Stock Location:

FPY9

0.00

12 BL 10-11-30

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

OK 10/12/01 JH

10-11-30
(12)

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NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 1:10:25 PM

Page 1

Work Order ID: 63575



Parent Item: D3564-5



Parent Item Name: Wearshoe

Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased		No		100	sf	178.9000	1.5	18.94737		18.10-11-16	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	178.9	
111323	0	
115688	18.9	
115953	160	115953

Q

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63523
Description: Wearshoe	Part Number:	D3564-5
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>R</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: 10-11-16	Date: 10/11/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
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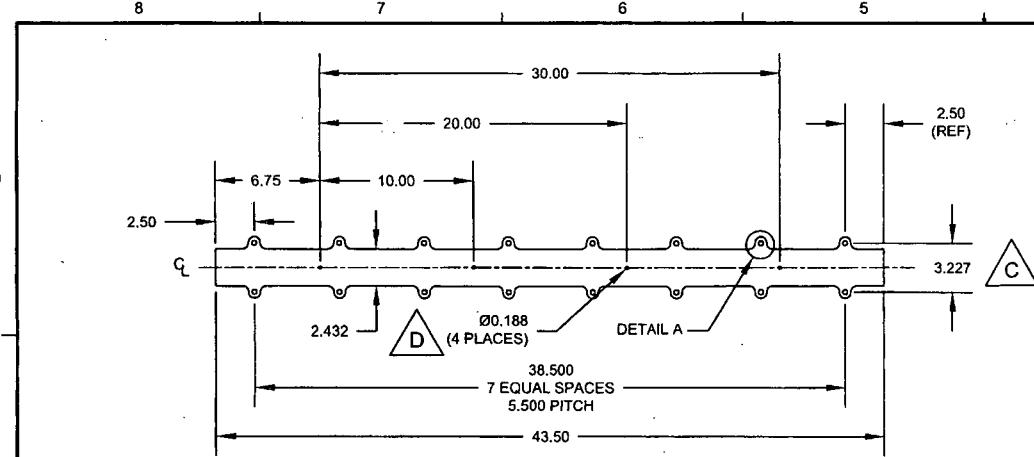
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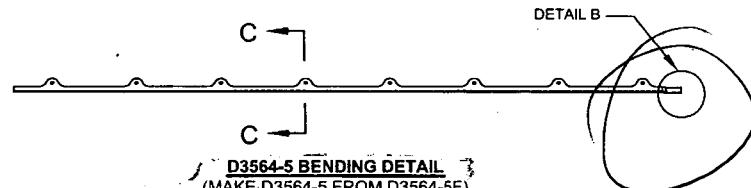
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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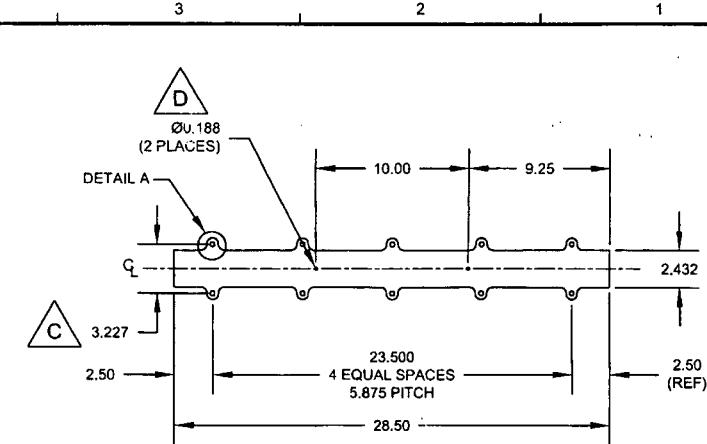
NOTE: Date & initial all entries



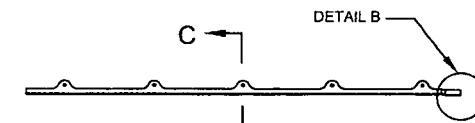
D3564-5F FLAT PATTERN



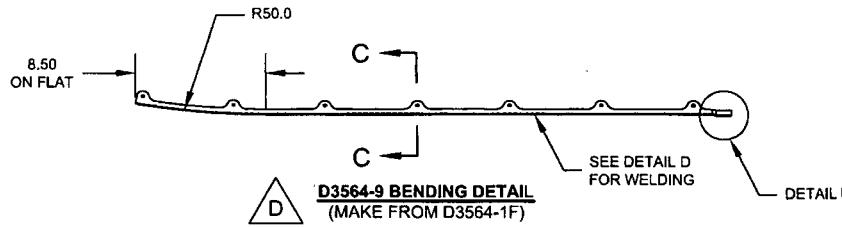
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



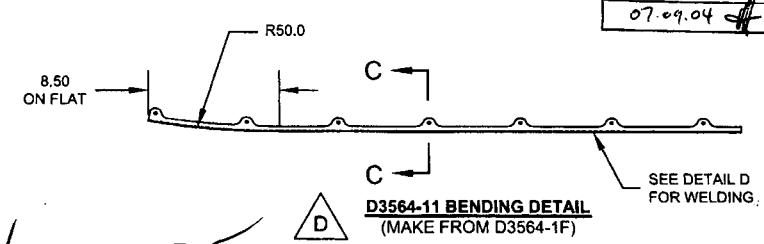
D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

wo 43575

DESIGN	PH	DART AEROSPACE LTD		
DRAWN	CD	HAWKESBURY, ONTARIO, CANADA		
CHECKED	PH	DRAWING NO.	REV. D	
MFG. APPR.	21	D3564	SHEET 2 OF 3	
APPROVED	NO	TITLE	SCALE	
DE APPR.	SH	WEARSHOE	1:8	
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS A PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

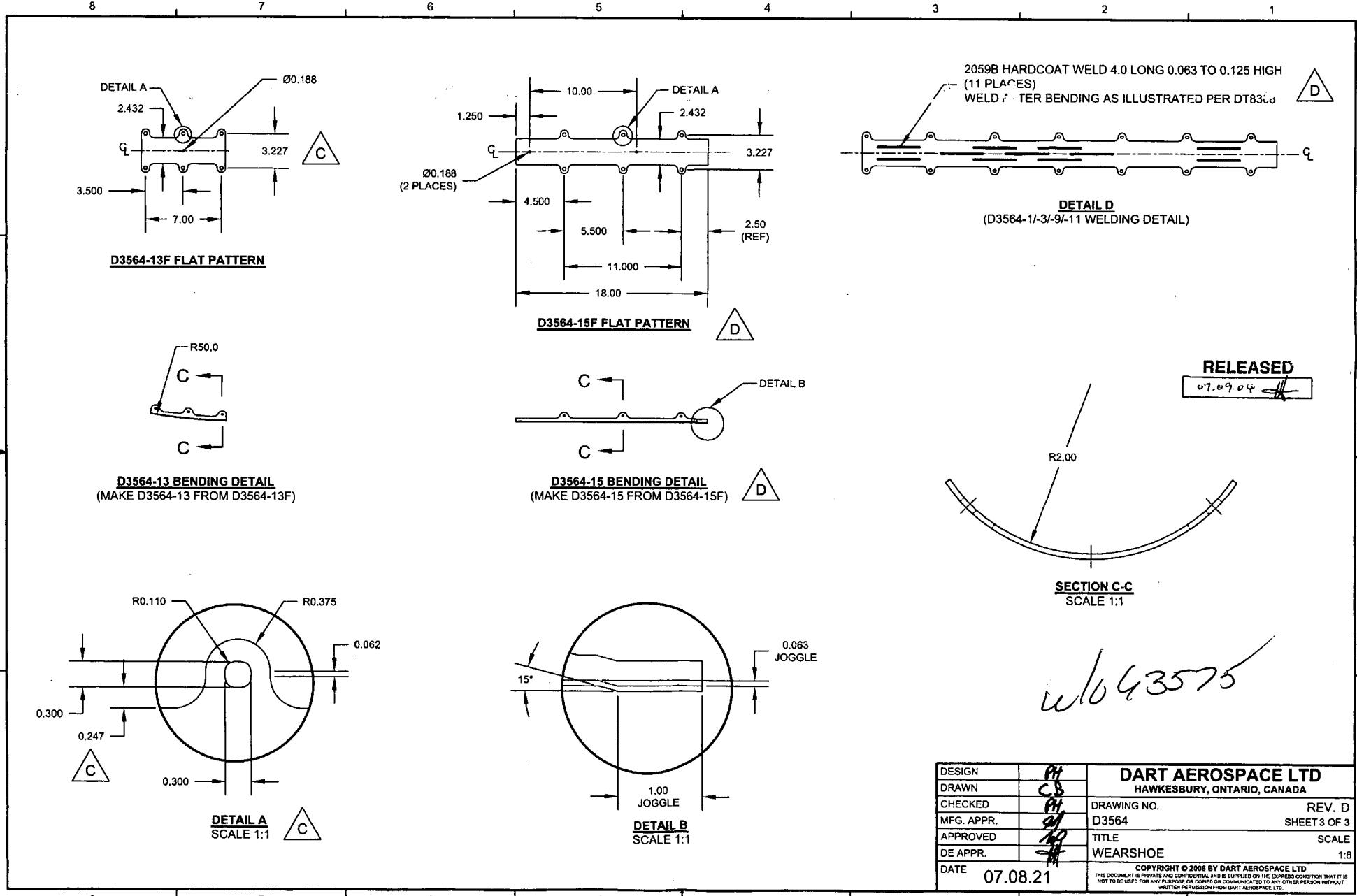
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DESIGN	<i>PH</i>	DART AEROSPACE LTD
DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	REV. D
MFG. APPR.	<i>SH</i>	DRAWING NO. D3564
APPROVED	<i>SH</i>	SHEET 3 OF 3
DE APPR.	<i>SH</i>	TITLE WEARSHOE
DATE	07.08.21	SCALE 1:8

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